



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.8510
Job Sheet 202745



Part No: 647.8510

Job Qty: 30 pcs

Part Name: Insert



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Due Date: 12/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C IPP REV:A NEW ISSUE 16-11-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	30 pcs	12/13/19	12/13/19	1.00	8.79	Doosan - 1		
110	QC 2	30 pcs	12/13/19	12/13/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S229462



Part: 647.8510
Job No: 202745
Serial No/Batch: S229462

Revision:
Inspector:
Exp Date:
Instructions:

Date: 11/05/19

120 QC 8	30 pcs	12/13/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	PML 19/11/05
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
122 Outsource - 17 - Passivate	30 pcs	12/13/19		GRO002-VC 7	209-11-06
123 Packaging 2-1 - Receive - B4B	30 pcs	12/13/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	NOM, 1-8-2019
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
124 QC 6	30 pcs	12/13/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	NOV 27 2019
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	30 pcs	12/13/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS 74 NOV 27 2019
					Packaging 3 - 5 - B4B	9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

1.661
839

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	30 pcs	12/13/19	0.00 0.00	QC 21 - SA - 21	DAS 21
					9.00
					NOV 27 2019

Part Op 100 - Doosan (Doosan Lathe) 1-Turn as per Folio FB512 & Dwg 647.8500 Folio Rev: N/A Dwg Rev: N/C
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
122 - ISSUE PO: 45209 SUPPLIER: GROUPE ALTECH -Passivate, MIL-S-5002 TYPE 6 AS PER DWG -
Certificate of Conformity is required
123 - (Receive & Inspect for Damage & Mat'l Certs)
124 - (QC6- All purchased or subcontracted products)
130 - (Identify as per dwg & Stock Location:) LOCATION: WA001
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.625	303 Round Bar 0.625"	1.5000 ft (.05 ea)	100-Doosan - 1	5150 409 5203772
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R0.625	2	19	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Insert	0.016Inches ± 0.005	0.021 0.011		
2	Insert	45.000Degrees ± 0.500	45.500 44.500	Angle	
3	Insert	0.020Inches ± 0.010	0.030 0.010	Radius	
4	Insert	0.210Inches + 0.005 - 0.001	0.215 0.209	Diameter	.207
5	Insert	0.300Inches ± 0.010	0.310 0.290	Diameter	.306
6	Insert	0.350Inches ± 0.010	0.360 0.340	Diameter	
7	Insert	0.060Inches ± 0.005	0.065 0.055		
8	Insert	0.283Inches ± 0.005	0.288 0.278		.284
9	Insert	0.560Inches + 0.000 - 0.010	0.560 0.550		
10	Insert	0.367Inches ± 0.005	0.372 0.362		
11	Insert	0.097Inches ± 0.005	0.102 0.092	Diameter	
12	Insert	0.075Inches ± 0.005	0.080 0.070	Depth	

Plex 11/1/19 12:31 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Misaligned/off center ☐ Folio/Program ☐ BOM/Route ☐ Grain Direction ☐ Broken/Damage/Defect ☐ Weld ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Drill Holes ☐ Out of Sequence ☐ Fit/Function ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045009



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045009

PO Date: 11/5/19

Due Date: 11/13/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

2019-11-13

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202745	647.8510	647.8500 Rev NC	Insert ISSUE PO: SUPPLIER: GROUPE ALTECH - Passivate, AS PER MPP- 172 Section 6.0 - Certificate of Conformity is required	Firmed XSE	-	11/13/19	50 pcs	0 pcs	50 pcs	\$2.50/pcs	\$125.00
Grand Total:												\$125.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

Plex 11/13/19 8:32 AM Dart.Guerin.Kimberley



55, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

FM-1020 Rev 20151005

Certificat de Conformité / Certificate of Compliance
(023895-1)

Bon de Livraison / Packing Slip
023895 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
15-Nov-2019	Jigar Patel		POHB045009					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	647.8510 Rev.	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] AS PER MPP-172, SECTION 6.0 THAT IS IAW QQ-P-35C TYPE - 2 TRY 1 PART FIRST	PASSIVATION CH	50	50	0	0	0

RECEIVED
NOV 18 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. Jigar

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.
We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.